

Date: Monday, 26/05/2008 1:11:59 PM  
 User: Linda Lacelle

## Process Sheet

OK

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : END FITTING ASS'Y LH  
 Job Number : 39484  
 Estimate Number : 13344  
 P.O. Number :  
 This Issue : 26/05/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : R & D LG FAB  
 Previous Run :  
 Written By : M 08/05/20  
 Checked & Approved By :  
 Comment : Est Rev:A 08-05-20 new issue DD verified by:

Part Number : D3763043  
 Drawing Number : D3763 PROTO  
 Project Number : IA0004  
 Drawing Revision : PROTO 28.05.20  
 Material :  
 Due Date : 02/06/2008 Qty: 2 Um: Each

## Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0 D37631 End Fitting



Comment: Qty: 2 0000 Each(s)/Unit Total: 2 0000 Each(s)  
 End Fitting  
 batch: 339483

Pl 08.05.29

(X2)

3.0 D37635 Tube



Comment: Qty: 1 0000 Each(s)/Unit Total: 1 0000 Each(s)  
 Tube  
 batch: 339468

Pl 08.05.29

(X2)

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
 1-make a 0.063" chamfer on D3763-1 fitting before ass'y  
 2-assemble as per dwg D3763 using locating pin DT 9014  
 \*\*\*\*\*look at dwg before assembling parts (LH)\*\*\*\*\*  
 3-weld as per dwg D3763 QSI004  
 Alum. rod Batch: m 106834

Pl 08.05.29

(X2)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END FITTING ASS'Y LH

Job Number: 39484

Part Number: D3763043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/08/05/29

(2)

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING  
APPROVAL**



LPTD

Comment: INSPECT WORK TO CURRENT STEP

# 06.05.20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



**FOR ENGINEERING USE ONLY**



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock  
Location: \_\_\_\_\_

N/A.

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

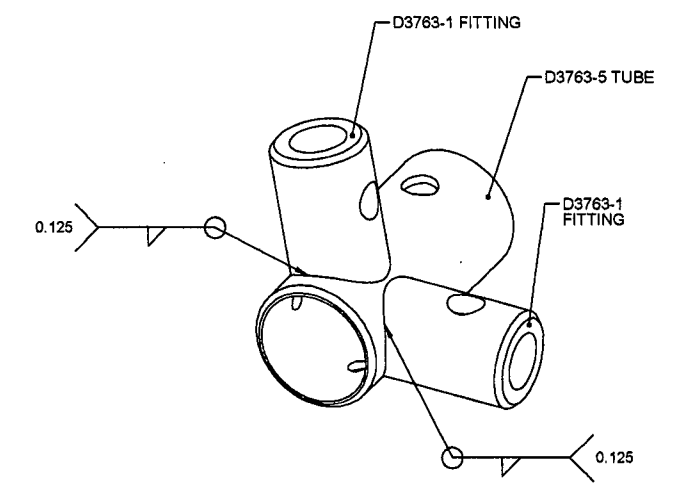
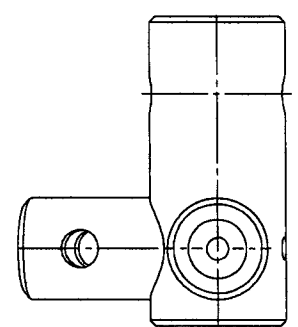
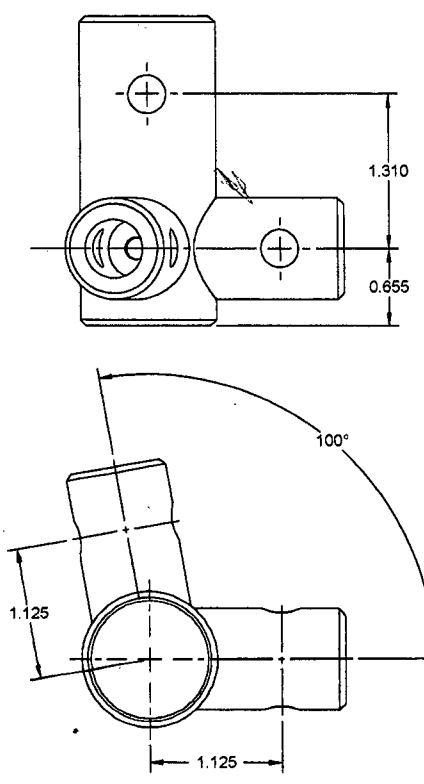
A.08.06.02  
Prototype

Job Completion



Change to W/O #0096

u 28.06.11



**D3763-043 END FITTING END FITTINGASSY, LH**

**PROTOTYPE**  
*Rev 06.05.30*

NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: ~~NONE~~ *chemical conversion coat per USS 005 4-1*  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.05 lbs  
 8) WELD: PER DART QSI 004

*06.05.30*

DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3763	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		END FITTING	1:1
DATE	08.05.22	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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